



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3650-3

Job Sheet 184883



Part No: D3650-3

Job Qty: 5 ea

Part Name: Center Panel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/18

Job Tracking No:

Due Date: 10/31/18

Created By: Shannon Hadley

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 07-09-27 DD verified by: EC IPP Rev:B ECN 1113P 08-01-22 DD IPP REV:C AS PER REV E 12-10-09 JLM VERIFIED BY:DD IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	5 pcs		10/31/18	0.00	1.09	Waterjet 1		SC 18/10/18
110	QC	5 pcs		10/31/18	0.00	0.00	QC2 Waterjet-2		SC 18/10/18
120	QC	5 pcs		10/31/18	0.00	0.00	QC8-3		38
130	Brake NC	5 pcs		10/31/18	0.00	2.48	Brake NC 1		DAS 30 9-89
140	QC	5 pcs		10/31/18	0.00	0.00	QC5		DAS 38 9-89
190	Packaging	5 pcs		10/31/18	0.00	0.00	Packaging3	5-233	21 9-89
200	QC21-SA	5 Ea		10/31/18	0.00	0.00	QC21		2-88

Part Op 100 - 1-Cut as per Dwg D3650 Dwg Rev: E Prog Rev: E 2-Deburr if necessary
Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
130 - 1-Form as per Dwg D3650 using DT9426 2-bend as per dwg
140 - QC5- Inspect part completeness to step on W/O
190 - Identify as per dwg & Stock Location: _____
200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	6.2500 sf (1.25 ea)	100-Waterjet	5090402

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M304S20GA	6	255	0

Part Specifications

Specifications could not be found.

Plex 10/17/18 1:04 PM Dart.Hadley.Shannon

040184679



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Container No: S123961



Part: D3650-3

Job No: 184883

Serial No/Batch: S123961

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/01/10

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

INSPECTION SHEET

Drawing Dime	Actual	Method of Inspection	Comments									
<table border="1" style="width: 100%;"> <tr> <td colspan="2">DART AEROSPACE LTD</td> <td>Work Order: 184883</td> </tr> <tr> <td colspan="2">Description: Center Panel</td> <td>Part Number: D3650-3</td> </tr> <tr> <td>Inspection Dwg: D3650</td> <td>Rev: E</td> <td>Page 1 of 1</td> </tr> </table>				DART AEROSPACE LTD		Work Order: 184883	Description: Center Panel		Part Number: D3650-3	Inspection Dwg: D3650	Rev: E	Page 1 of 1
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Description: Center Panel		Part Number: D3650-3										
Inspection Dwg: D3650	Rev: E	Page 1 of 1										
FIRST ARTICLE INSPECTION CHECKLIST												
Drawing Dimension	Tolerance	Actual Dimension	Accept Reject Method of Inspection Comments									
0.276	+/-0.010	0.276	VSC Tape									
0.213	+/-0.010	0.214										
0.400	+/-0.010	0.399										
0.85	+/-0.030	0.852										
12.900	+/-0.010	12.900										
4.300	+/-0.010	4.303										
13.750	+/-0.010	13.750										
15.46	+/-0.030	15.46										
1.947	+/-0.010	1.950										
5.894	+/-0.010	5.895										
8.267	+/-0.010	8.270	DAS 38									
9.187	+/-0.010	9.190										
15.53	+/-0.030	15.534										
13.60	+/-0.030	13.60										
2.286	+/-0.010	2.290										
7.190	+/-0.010	7.193										
9.570	+/-0.010	9.570										
10.850	+/-0.010	10.850										
12.097	+/-0.010	12.097										
10.509	+/-0.010	10.509										
0.040	+/-0.010	0.036										

Measured by: S	Audited by: 9-89	Preliminary Approval:
Date: 18/10/29	Date: NOV 06	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	
B	12.03.09	Dwg Rev updated	KJ	
C	12.08.26	Dimensions updated per Dwg Rev D	KJ	
D	12.10.26	Dimensions updated per Dwg Rev E	KJ	

H:\FORMS\Quality Assurance\approved QA\Inspection Sheet revE

Measured by:	Checked by:	QC Inspector:
Date:	Date:	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	